

One Piece Products Patent Pending



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Installation Manual



One Piece Products

Conversion kit

Series 1

1973-1991 GM Truck bodies



First and foremost I would personally like to thank for your interest in this one piece window conversion. It was designed to be installed by a novice. In this kit you will find all the necessary hardware needed to perform the conversion. Please keep in mind that the new felt assemblies will need a break in period and might need a little adjustment in the near future after the initial break in.

In the following pages you will find detailed pictures on the installation process. These pictures will have a short one to two line description of what is being done in the step mentioned.

If there are any difficulties that you can't figure out, Please feel free to reach technical support at **(888)663-7763** During the business hours of 9:00 a.m. to 4:00 p.m. Monday thru Friday – Pacific Standard Time.

KIT CONTENTS



1. **4" extension.** (Used to push back the original rear guide rail closer to the door latch.) **Quantity**

(2)



2. **Run Channel.** (Used to replace the old run channel with a new longer one.) **Quantity**

(2)



3. **Roller Channel** (Used to replace the old roller channel, has two holes one on each end including fold down tabs.) Mounts between door glass brackets and the rollers on the regulator .

Quantity (2)



- 4. Front Main Guide** (Used to guide the front part of the door glass in a vertical motion parallel with the back guide.) Marked **Left** or **Right**

Quantity (2)



- 5. Rubber Spacer $\frac{1}{2}$ "x $\frac{1}{4}$ "** (Used to take the voided space left by the original vent glass assembly. **Cut to size.** (8 pcs 7" long and 6pcs. 4" long.

Quantity (80"long)



- 6. Trim Adhesive** (Used to glue on felt and scraper assembly including the Rubber Spacer.)

Quantity (1)



7. **Plastic Plugs** (Used to cap off original holes left by the old vent glass assembly). Requires a little dab of trim adhesive before installation.

Quantity (6)



8. **Outside Scrapers** (Used to replace the old scrapers with original looking new ones. **Glue On** – make sure to put the glue on the body so as not to make too much of a mess.

Quantity (2)



9. **Hardware** (Nuts, bolts, washers, plugs, expansion nuts,) **Quantity**
(assorted)

10.



Tempered Door Glass (Used to make

your truck look better)

Left & Right including brackets

Quantity (2)

11.



Felt Tape (Used on the

inside corners to prevent any scratches from happening during installation.) cut to size.

Approximately cut to 3" lengths

12.



New inside door panel scraper (Used

on inside door panel for anti rattle of glass.

Quantity(2)

Tools required

- Small hammer.
- 1 ½" hole saw with Drill.
- Drill or hand screwdriver with Phillips head tip.
- Flat thin screwdriver.
- 1/4" nut driver or ratchet with 1/4", 10mm, 7/16" socket and 1/2" crescent wrench.
- 1/4" drill bit.
- 7/16" wrench.
- Hand rivet gun w/ various tips.
- Metal saw to cut sheet metal (hack-saw).
- Small angle grinder(electric or air)
- (PATIENCE)
- 6-Pack – lawn chair optional for breaks. .

Installation steps

(Please remember to follow the steps carefully.)

Brief disassembling steps:

1. Begin by taking all the screws from the door panel. Take the C-clip from the door handle off, if in case it is a manual regulator assembly.
2. Some older models only have **2** vent assembly screws exposed on the external part of the vent assembly (Most will have **3** screws.) Unscrew all of them and take them off.



3. With the door panel off you will see two 7/16" Bolts lined up at the bottom of the vent assembly. Take them off. **(See above picture.)**
4. Next to the spring located at the bottom of the vent glass frame pivot point is a 1/4" bolt, you must also remove this bolt in order to pull the whole vent window assembly out.

a. **Tip to remember**: in order to pull the vent window assembly out, the door glass must be in the bottom position. Proceed to remove vent glass assembly.

5. After removing the vent glass assembly, proceed to remove the door glass by rolling up the door glass to the very top position where the metal roller channel is in direct view, Slide the Door glass forward until it is completely out.

a. **Tip to remember**: Make sure to be careful on sliding the door glass forward so as not to hit the frame of the actual door.



6. After the Door Glass and Vent Glass Assembly have been removed, continue to remove all the old felts and scrapers that are left on the door. **(the old brittle fuzzy stuff)**

Assembling steps:

7. Continue on by removing the rear vertical guide that is right next to the latch assembly of the door.



- a. After you remove the rear vertical guide find **the 4" extension** that is included in your kit and bolt one end of it as seen in the picture below. The hole on the opposite side is for the original hole on the door skin which will push the guide closer to the

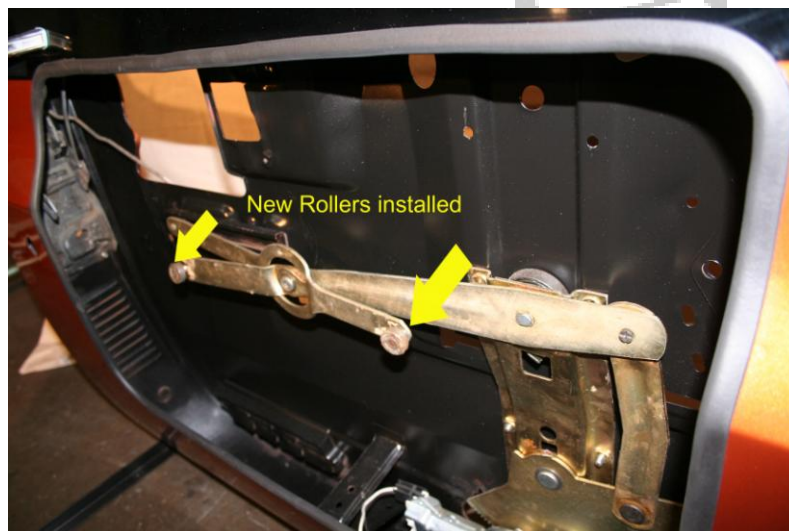
door latch assembly



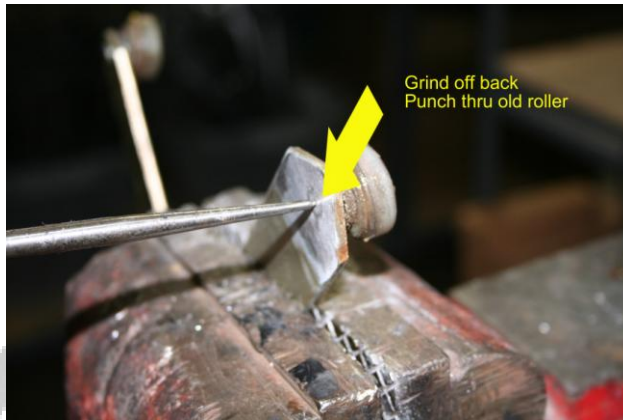
b. Don't Forget to Slot the Hole for future adjustment



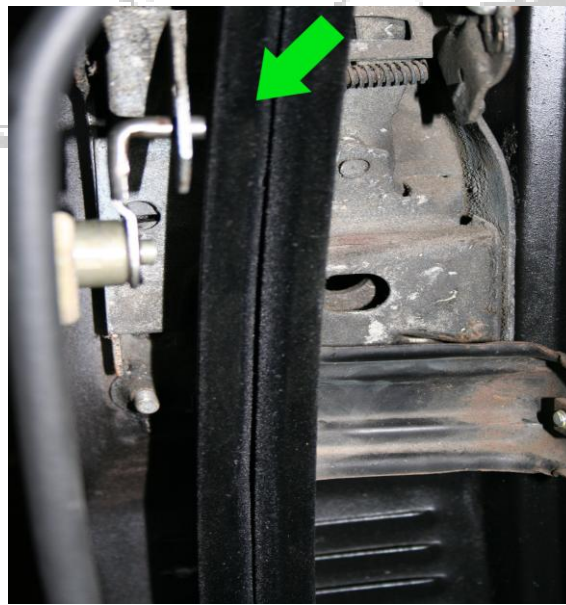
Roller install Important tip: Remember to remove the regulator assembly if you need to change the new rollers that come with this kit. (Just remember to grease the roller run channel and the front slide guide bracket.)



Below are pictures howing the new roller installation:

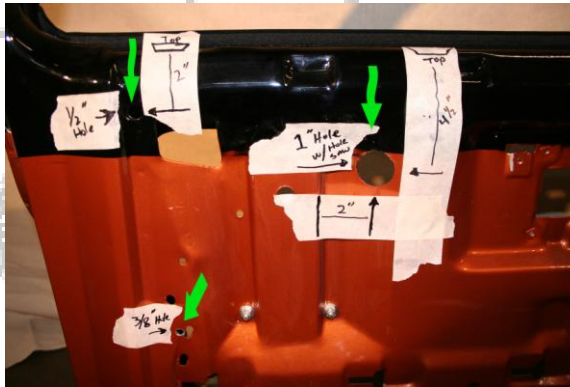


8. Door Lock Tumbler cutting In the next step you will have to cut the tip from the elbow that engages to the door latch assembly, **simply refer to the pictures below.** If this piece is not cut, it will be in the way of the window during vertical motion. **(VeryImportant) Step.**



In this step your lock assembly should **look like the picture**
above.

9. Using Hole template In this step you'll be **using a template** to drill 3 holes in the door. One 1/2" hole, one 3/8" hole, and finally one 1 1/4" hole. The template is usable for both left and right sides. Simply line up to the original **4 bolt holes of the manual regulator** assembly to those on the template. The holes are also measured and indicated in the pictures below.



10. Cut & Fold In this step we will be cutting and folding the reinforcement support that crosses the lower horizontal opening with the hack-saw. (See picture below.)

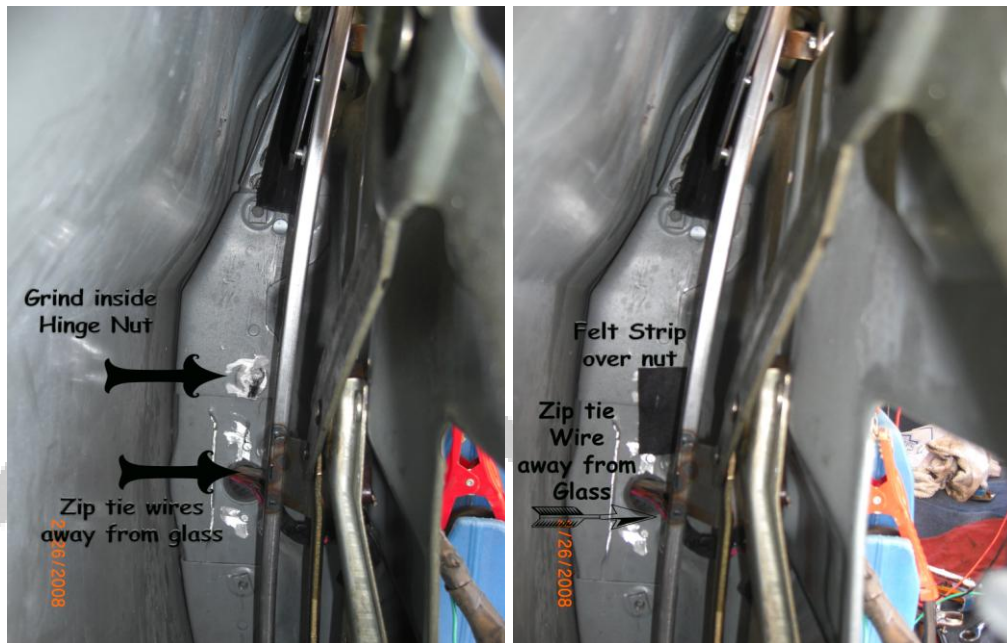


Quick Note: Some doors will weaken due to this cutting. There is a step to help in the event of this. Take a 1" x 1/4" straight bar and either JB Weld it to the inside lip of where the New scraper mounts or Weld it in place, Only if your are able too weld ofcourse. If you show a gap after the installation of glass between the center of the glass and the scaper. Simply Finessely rub the outside of the scraper area with the window in the down position till the gap is closed. The sheet metal is flexible. **Don't press too hard on the outside , this can cause a kink in your sheetmetal.**



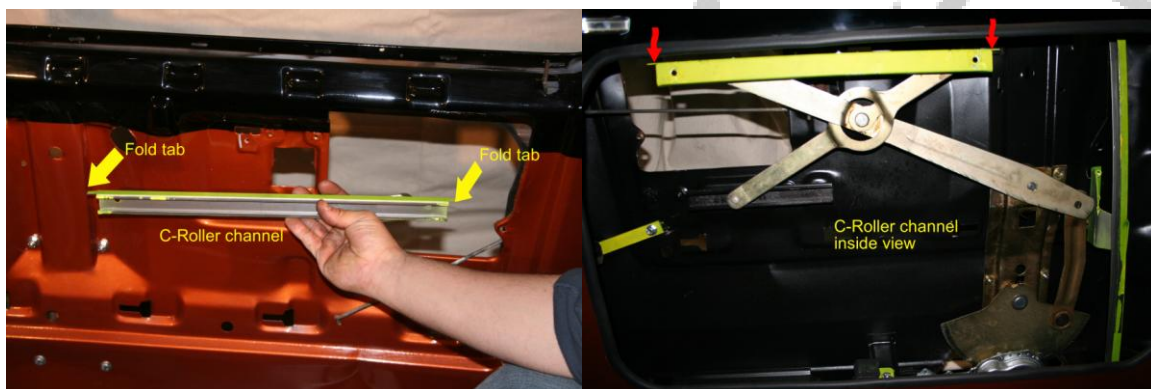
11. Grinding Inside Hinge compression nut. On some doors you will have to grind FLAT the inside hinge nut that is pressed on the door itself. We supply the NEW shorter Bolt, but the glass may hit this nut when about Half way down.

See pic for example.



This is an inside shot of the door facing the hinge

12. New C-Channel installtion The C-roller channel which is fairly easy, simply slide the C-channel onto the new rollers



13. Plastic plug installation In this step we will install **the plastic plugs** provided in the kit assembly. These plugs cover the original holes that would were left by removed vent glass assembly. **Quick tip: (add a little dab of weather-strip adhesive to the plug so it will not pop out while driving.)** There are two different sizes of plugs that fit each hole appropriately, **PLEASE PAY ATTENTION** to the picture below.

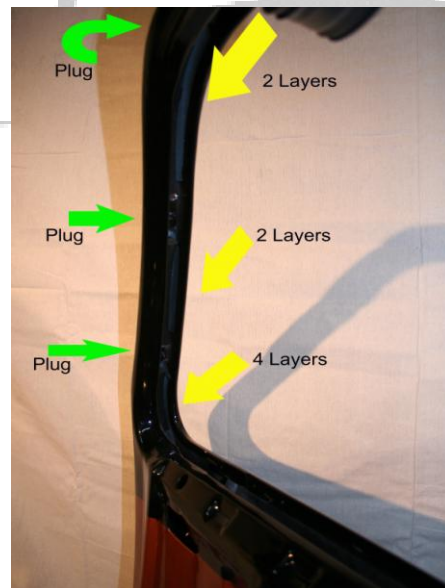
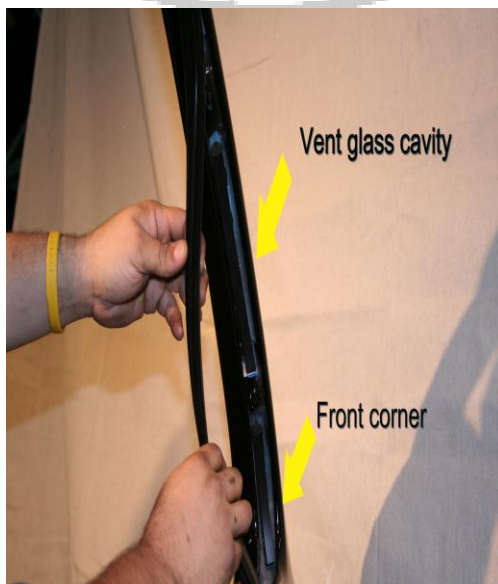


14. In step we will be installing **the felt assemblies**, including **the inner and outer scrapers** and **the required back spacer**. **Quick Tip:** Add adhesive to the felts and scrapers during installation. See picture below

Quick tip: You might need to widen the opening for the run channel. It should roughly be 1" wide around the perimeter where the New run channel goes.



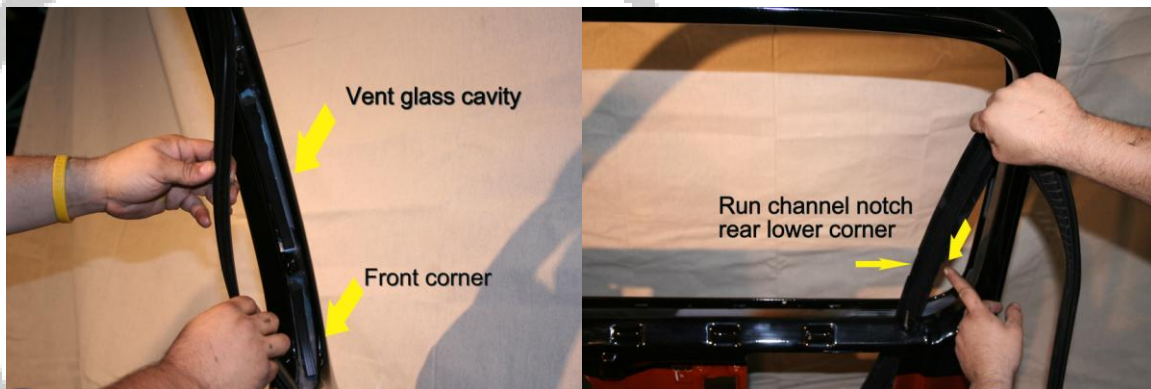
Vent Spacer installation



In this picture on top, the **yellow arrows** indicate the position of the
the
Spacers, while the **green arrow** indicate the inside view of the plastic
plugs

Installed on the previous step. The bottom corner nearest the
horizontal
curve should consist of **4 layers cut 4" long** while the middle and
upper
Section should only be **2 layers cut 7" long of the 1/2" x 1/4"**
spacer.

15. Following the spacer install, we continue with **the run Channel install** indicated in the pictures below. **Quick Tip:** Notice the notches on the sides of the run channel, they are the indicators of where to start the install. The notch further from the end of the run channel goes on the back corners of the door.



Make sure the front of new Run Channel **looks like the bottom picture.**



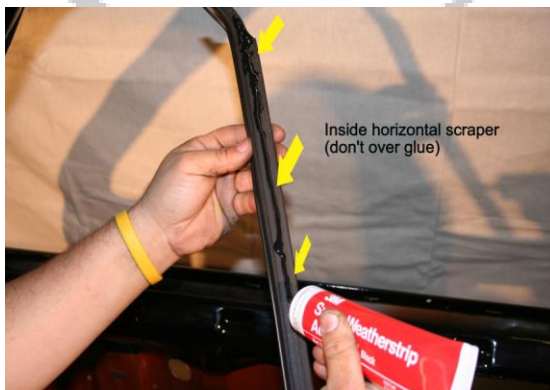
Some trucks will only require **3 layered** spacers while others will require the full four. I like to also

use expanding insulation foam that is used on houses. You can pick this up at any Home Depot.

16.Horizontal outer felt scraper installation:



Do a dry run and make sure the outside scraper fits between the Glass run channels that go around the door frame. Then begin to glue the scraper with the weather strip adhesive provided.



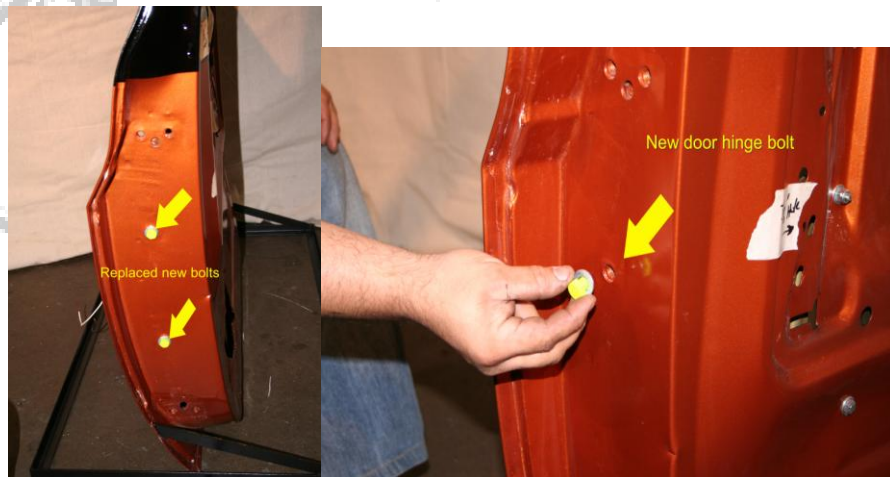
Make sure not to over-glue the new scraper and tape down after it has been lined up between both ends. The Tape can be removed after about 3 hours.

Quick tip: Have a little household paint thinner (*mineral spirits*) to clean up

any mess, This will not harm your paint in any way, just make sure to use it right away before the glue dries.

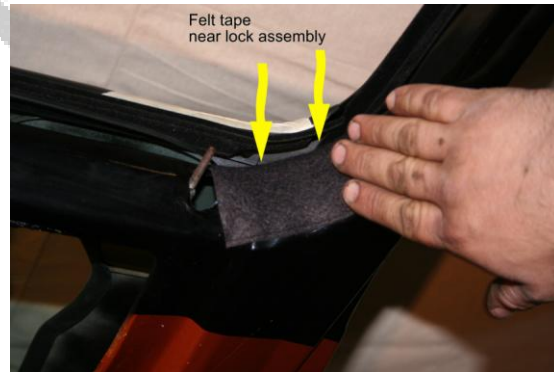
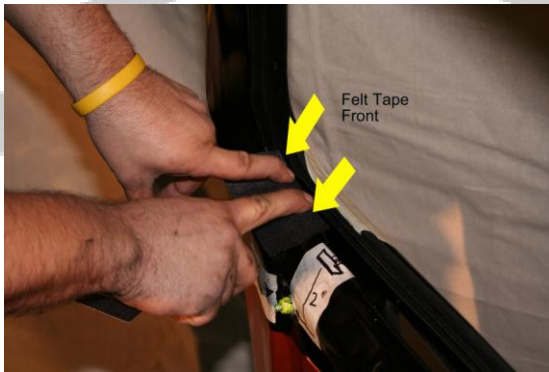
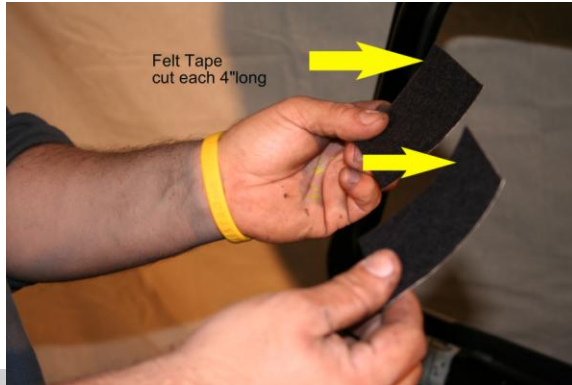
17. Installing front new Hinge Bolts:

The following step will consist of **removing two door hinge bolts** and replace them with two new ones per door. These bolts are shorter than the original ones. **Very Important** step, If not replaced you could possibly **break the glass when you roll it down.**



Installing Felt tape:

18. Here we will be installing **the felt tape** that will prevent scratching the glass when installing it in the door.



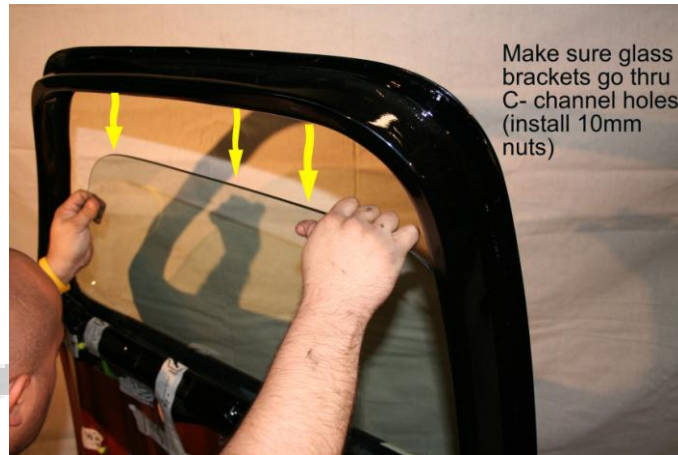
Installing tempered door glass:

19. Here we will be installing **the new curved tempered door glass.**

Just simply following the standard pictures. **Drill** a 1 ½" Access Hole as shown below. Exactly 3" from the original crank hole in the direction of the lock.

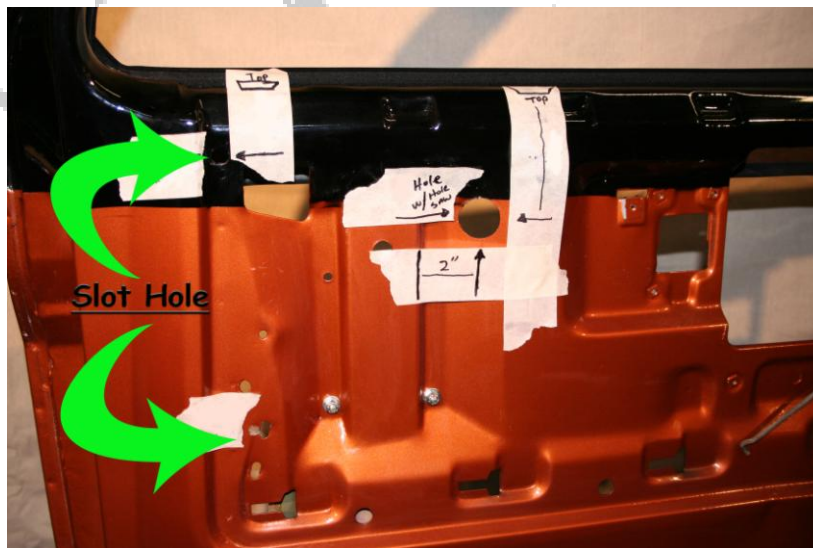


You can also install the glass from the outside as well!



Here we install the new **10mm** nuts on the brackets. (**Important step**) and then roll the window all the way up.

20. Installing new front vertical guide. Make sure the holes are predrilled and slotted according to the template provided.



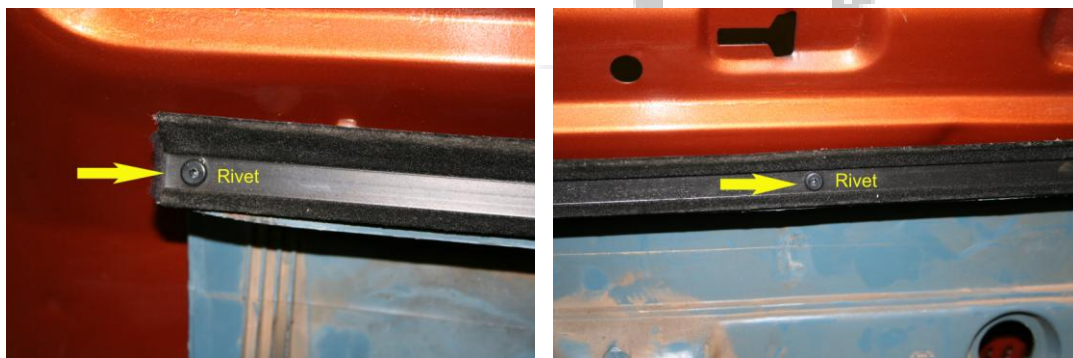
The glass should be in the up position. Slide the new vertical guide rail and finger tighten the bolts and check for travel. Even though it's a little loose you should be able to see if it is traveling almost

correctly. Roll it down then up and then tighten the nuts and lube all the moving parts.



Installing inner door panel scraper:

23. Take a 1/8" drill bit with a drill and place the new inside door glass scraper and center it on the door panel and drill to the proper height (like in the picture below.)





21. Adjustments

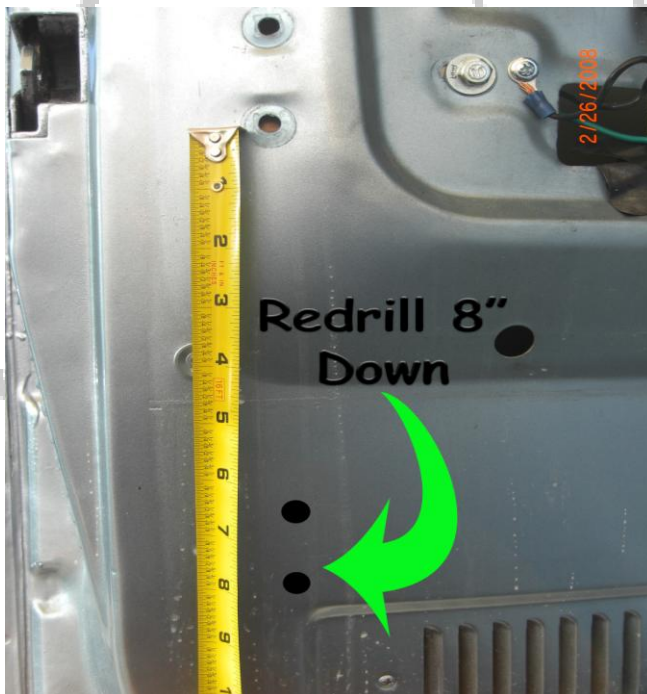
If for any reason the window does not go up and down properly there are adjustments that can be made by elongating the two of the vertical guide holes as seen in the pictures below. **(Only if needed)**

Quick Tip: (Please remember that the new felt assemblies need to be broken in for a couple of weeks.(2-3 weeks.) The window might not go completely up just shy of reaching the top, again due to the brand new Run Channels.



Power Lock actuator relocation

Just redrill the holes 8" down as shown below and go to your local hardware store and pick up some 1/8" round or square bar and bend it in a Z shape so it can fit the lock actuator and tie it together with a U-BOLT and nuts that are used to tie together cables and your done.

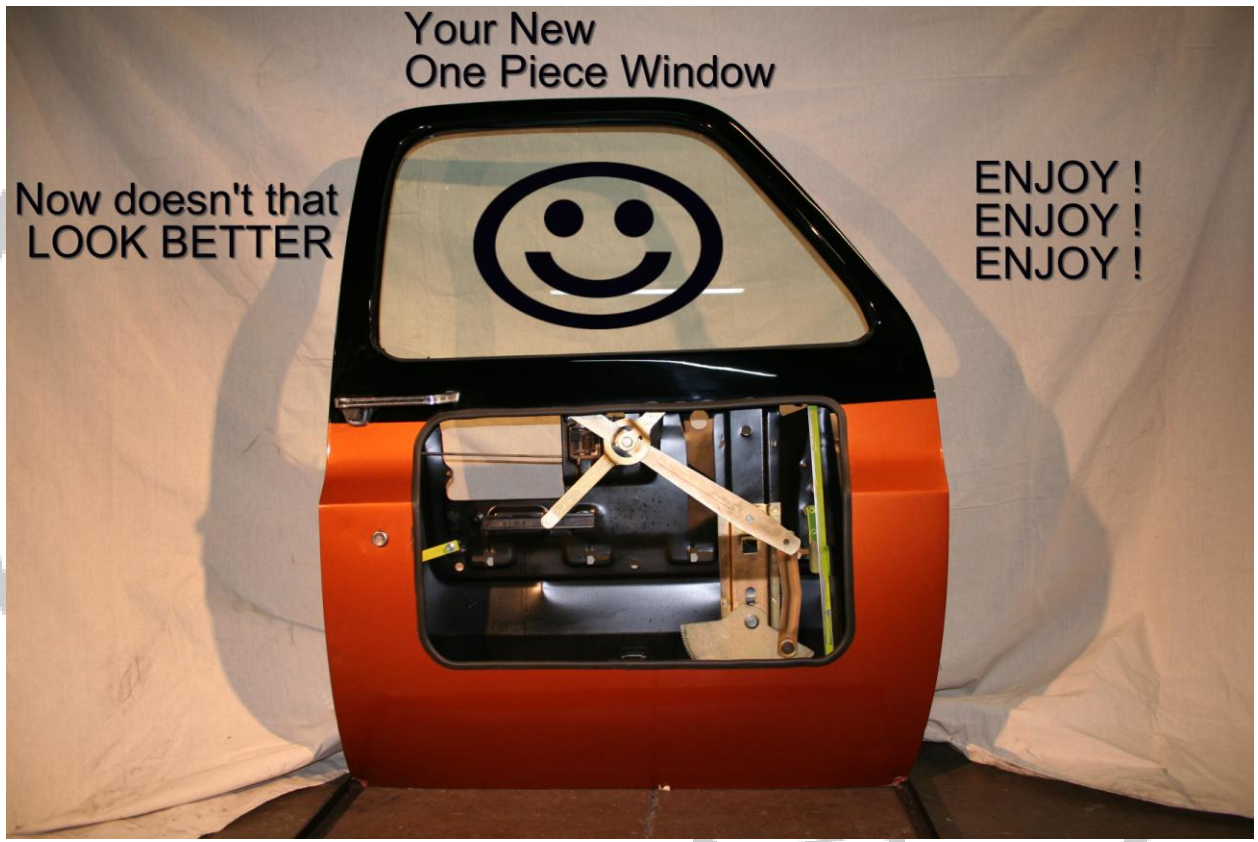


Widening the Run Channel Cavity



- Use **Wooden** end of a hammer to twist open the cavity of the **New Run Channel**. Open to roughly about 1" wide measured from the inside.

CONGRATULATIONS!!





Thank you
For purchasing
Our one piece kit.

